

WHAT IS CLAIMED IS:

1. A method of making a rim having hollow flanges formed on its opposite annular edges comprising the steps of:

5 cutting an elongated metal band of a fixed width to provide metal strips of a predetermined length;

rolling a selected metal strip of the predetermined length into a ring;

welding the opposite ends of the ring;

curling each annular edge of the ring outward; and

10 rolling the main annular part of the ring into a required shape.

2. A method of making a rim having hollow flanges formed on its opposite annular edges according to claim 1, wherein the opposite ends of the ring are flash butt-welded; and the burr or flash is removed from the welded part of the ring.

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3. A method of making a rim having hollow flanges formed on its opposite annular edges according to claim 2, wherein the main annular part of the ring is sandwiched between inner and outer rolls, and is roll-formed to define a well along the center line of the main annular part.

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4. A method of making a rim having hollow flanges formed on its opposite annular edges according to claim 3, wherein it further comprises the steps of:

bending the opposite bead areas toward the center well;

closing the gap between each curl edge and the bead area; and

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unbending the opposite bead areas into the final rim shape.

5. A method of making a rim having hollow flanges formed on its opposite annular edges according to claim 3, wherein it further comprises the steps of:

closing the gap between each curl edge and the counter bead area; and

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raising each closed curl edge into the final rim shape.